

Fig. 1

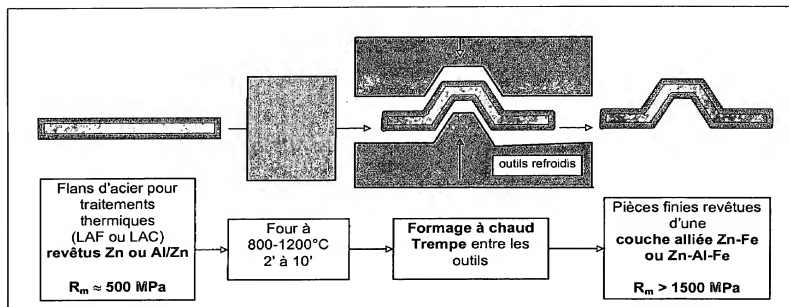


Fig. 2

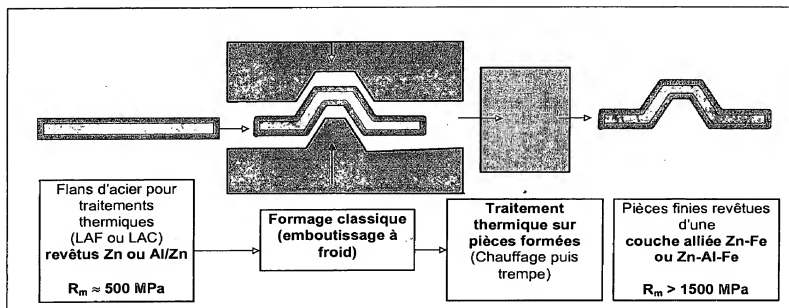


Fig. 3a .

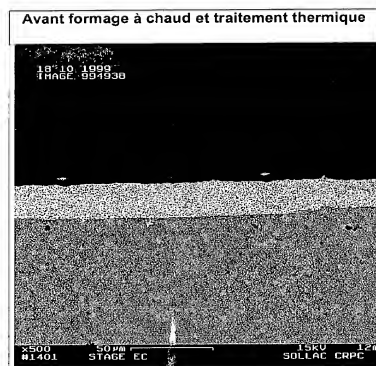


Fig. 3b.

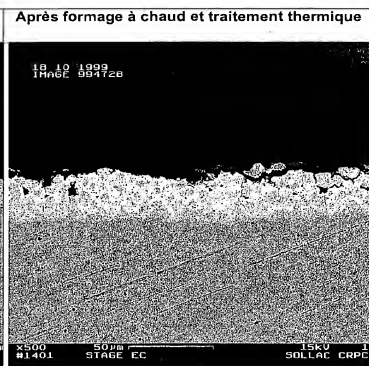


Fig. 4a.

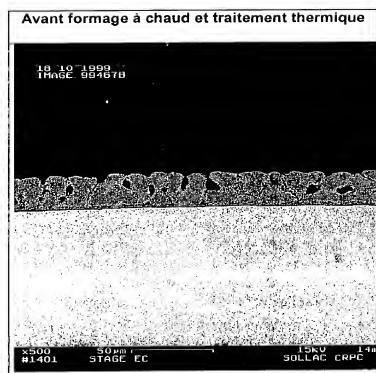


Fig. 4b.

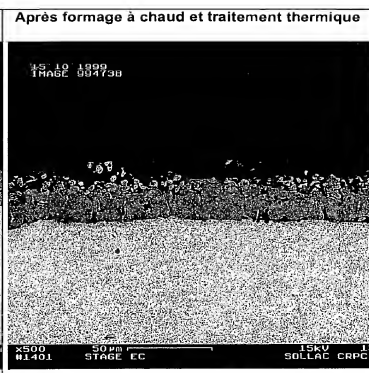


Fig. 1

Cooled tools

Steel blanks for heat treatment (Cold or Hot Rolled) with Zn or Al/Zn coating ts = approx. 500 MPa		Oven at 800-1,200°C 2 to 10 min.		Heat forming Quenching between tools		Finished parts coated with Zn-Fe or Zn-Fe-Al alloyed layer ts > 1,500 MPa
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Fig. 2

Steel blanks for heat treatment (Cold or Hot Rolled) with Zn or Al/Zn coating ts = approx. 500 MPa		Conventional forming (cold stamping)		Heat treatment on formed parts (Heating then quenching)		Finished parts coated with Zn-Fe or Zn-Fe-Al alloyed layer ts > 1,500 MPa
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Fig. 3a.

Before hot forming and heat treatment

Fig. 3b.

After hot forming and heat treatment

Fig. 4a.

Before hot forming and heat treatment

Fig. 4b.

After hot forming and heat treatment

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